

Date: Monday, 02/02/2009 8:05:20 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 45376		
Estimate Number	: 13758		
P.O. Number	:	Part Number	: D3877043 ⁴¹
This Issue	: 02/02/2009 S.O. No. :	Drawing Number	: D3877 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: PREL
Previous Run	: 45375	Material	:
Written By	: <u>JP/09-02-02</u>	Due Date	: 09/02/2009 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 09-01-30 JLM Verified By:EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

~~6061T6 BAR 375X.750~~

6061T6 BAR 375X.750



Comment: Qty.: 0.3893 f(s)/Unit Total : 2.3360 f(s)
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x00.750) Batch: 118037

mmf 09/02/02

2.0

BAND SAW

BAND SAW



Comment: BAND SAW 3.700
 Cut blanks: 0.750" x 0.375" x ~~2.750~~" long

mmf 09/02/02

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA798 and Dwg D3877
 Dwg Rev PREL Fa19 Folio Rev AA

mmf 09/02/02

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/02/02

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JP/09-02-05

Date: Monday, 02/02/2009 8:05:20 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45376

Part Number: D387704841

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D3877

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

10.0 MS21069L5

Nutplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nutplate

BATCH: M110765

11.0 MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Rivet

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2872

2-Identify as D2872-041

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

Date: Monday, 02/02/2009 8:05:20 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45376

Part Number: D3877048 41

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C209/03/21 (6)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/25 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.02.02

AUTH L

RELEASED W

DATE 09.03.24

UP

09.02.28

ART AEROSPACE LTD		Work Order: 45376
Description: Nut Plate assembly		Part Number: D3877-51
Spec Dwg: P-1	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

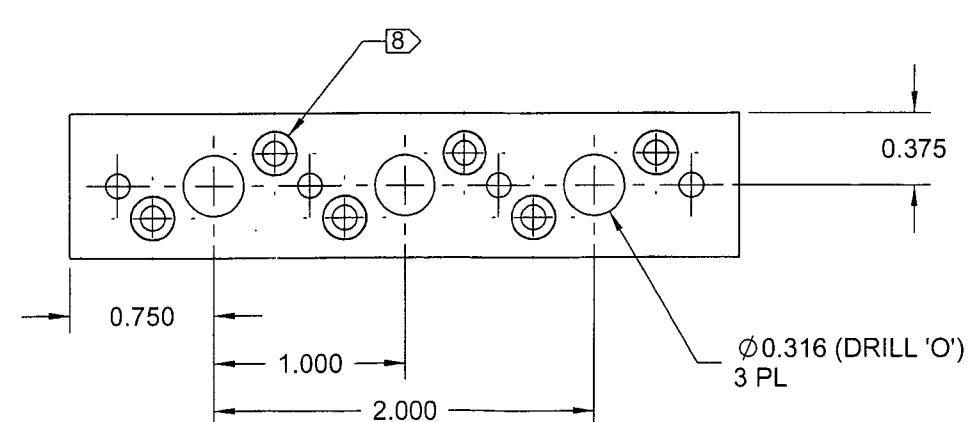
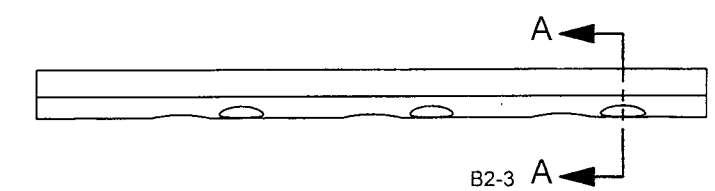
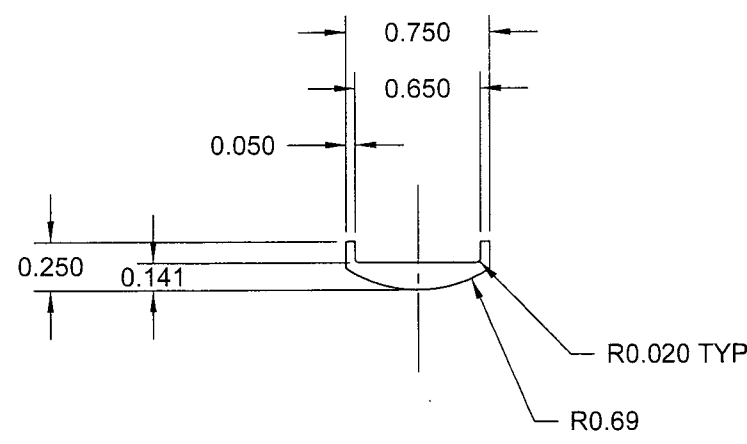
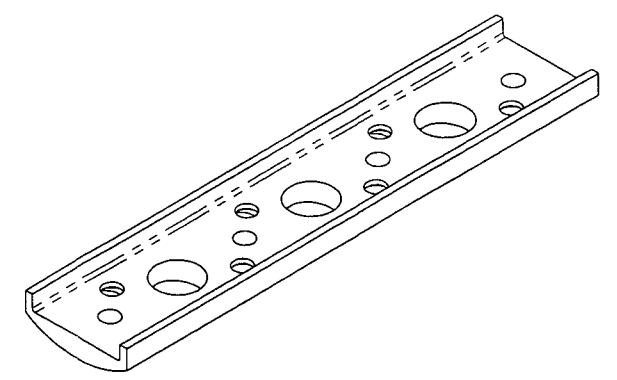
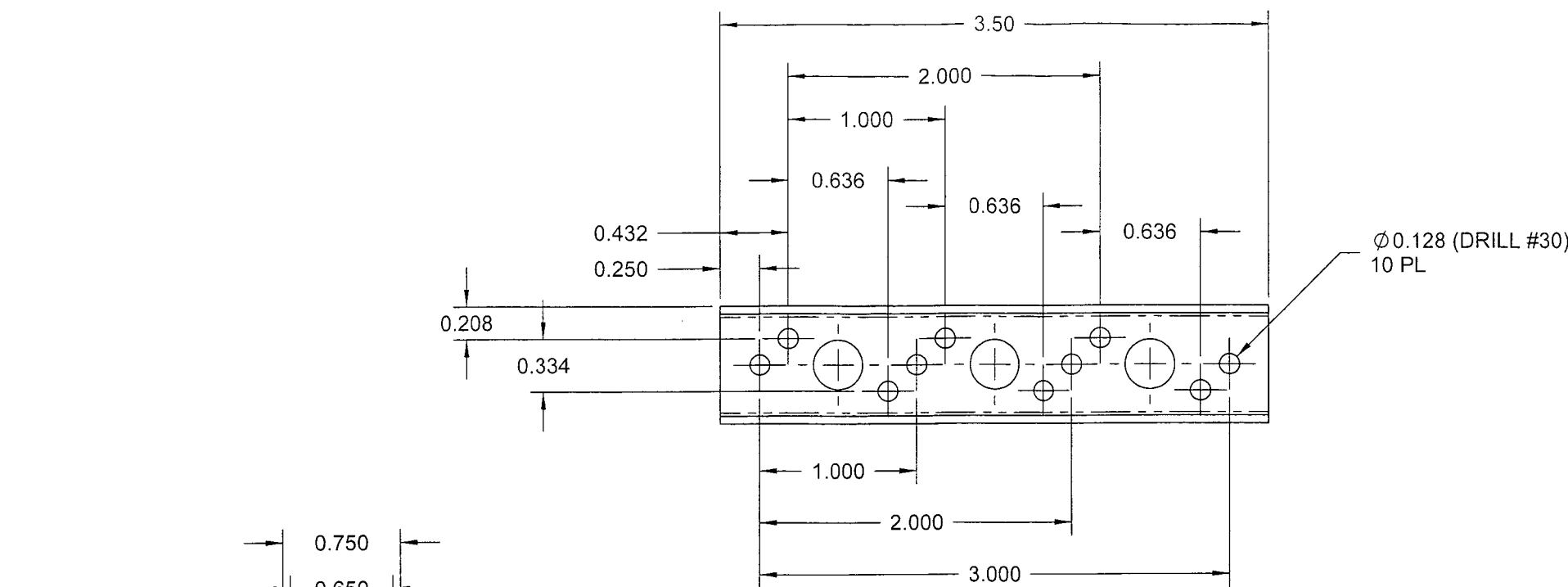
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.750	±.010	.751	✓			
.650	±.010	.650	✓			
.250	±.010	.251	✓			
.141	±.010	.141	✓			
.050	±.010	.051	✓			
R.020	±.010	.015	✓			
R.69	±.03	R.69	✓			
3.50	±.03	3.50	✓			
2.000	±.010	2.001	✓			
1.000	±.010	1.000				
.636	±.010	.635	✓			
.432	±.010	.431	✓			
.250	±.010	.250	✓			
.208	±.010	.208	✓			
.375	±.010	.374	✓			
.750	±.010	.748	✓			
Drill #30 (.128)	±.005 - .001	Ø .130	✓			
Drill #0 (.316)	±.006 - .001	Ø .317	✓			
.068	±.010	.068	✓			

Insured by: mmf	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/02/05	Date: 09.02.05	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	

110 D3877-041



D3877-1 RADIUS BLOCK

- NOTES:**
- 1) MATERIAL: 5052-H32/H34 BAR (REF DART SPEC. H5052H32B0.750X00.250) OR 6061-T6 BAR (REF DART SPEC. M6061T6B0.750X00.250)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.03 lbs
 - 8) C'BORE INDICATED HOLES ON CURVED SIDE $\varnothing 0.230 \times 0.068$ DEEP + C'SINK CURVED SIDE $\varnothing 0.225 \times 100^\circ$ (SEE SECTION A-A), 6 PL

**PRELIMINARY
ISSUE**

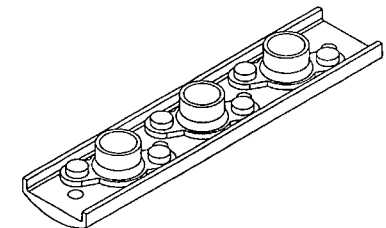
45376

07.01.21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3877	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RADIUS BLOCK	NTS
DATE	09.01.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

PARTS LIST

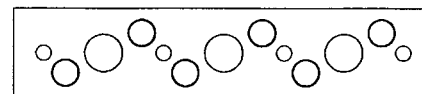
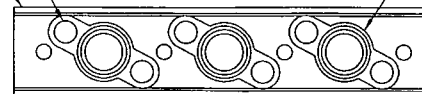
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3877-041	RADIUS BLOCK
2	1	D3877-1	RADIUS BLOCK
3	3	MS21069-L5	NUTPLATE
4	6	MS20426AD4-5	RIVET



MS20426AD4-5 RIVET
6 PL

D3877-1

MS21069-L5 NUTPLATE
3 PL



45376

D3877-041 RADIUS BLOCK

RELEASED
09/03/21

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3877-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.05 lbs

A	NEW ISSUE	CP	09.01.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3877	REV. A SHEET 1 OF 4
TITLE RADIUS BLOCK	SCALE NTS

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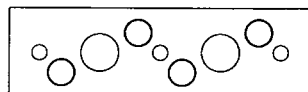
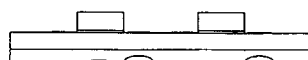
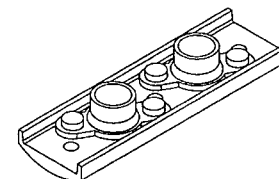
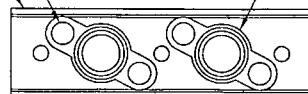
PARTS LIST

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3877-043	RADIUS BLOCK
2	1	D3877-3	RADIUS BLOCK
3	2	MS21069-L5	NUTPLATE
4	4	MS20426AD4-5	RIVET

MS20426AD4-5 RIVET
4 PL

MS21069-L5 NUTPLATE
2 PL

D3877-3



D3877-043 RADIUS BLOCK

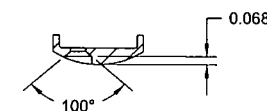
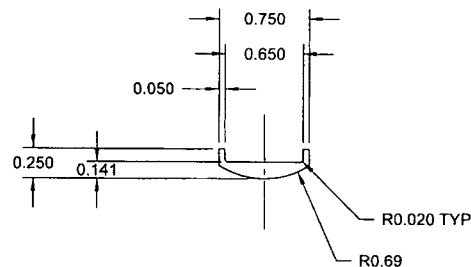
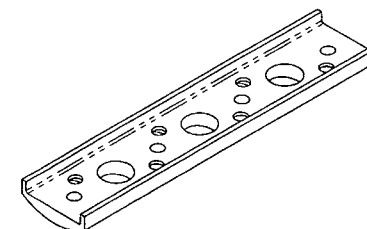
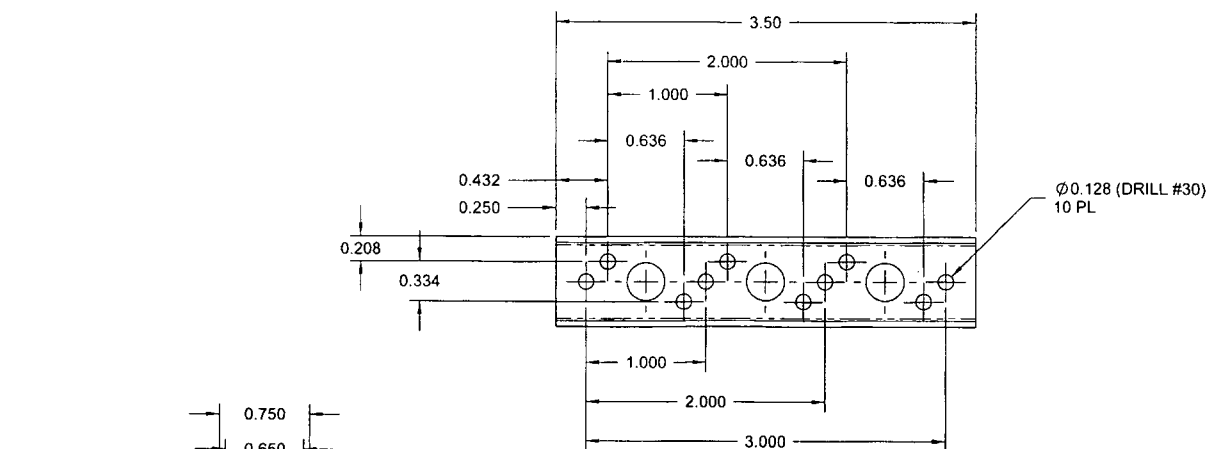
45376

RELEASED
09/03/21 NW

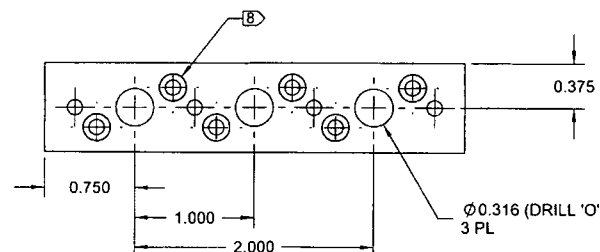
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3877-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Pd	DRAWING NO.	REV. A
MFG. APPR.	9	D3877	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	RADIUS BLOCK	NTS
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SECTION A-A B4-3



45376

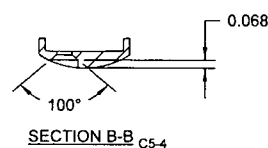
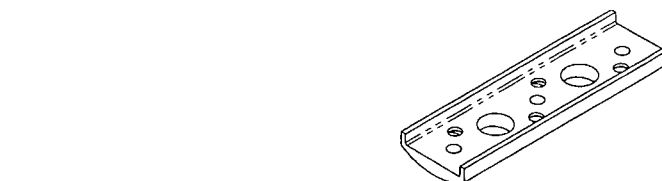
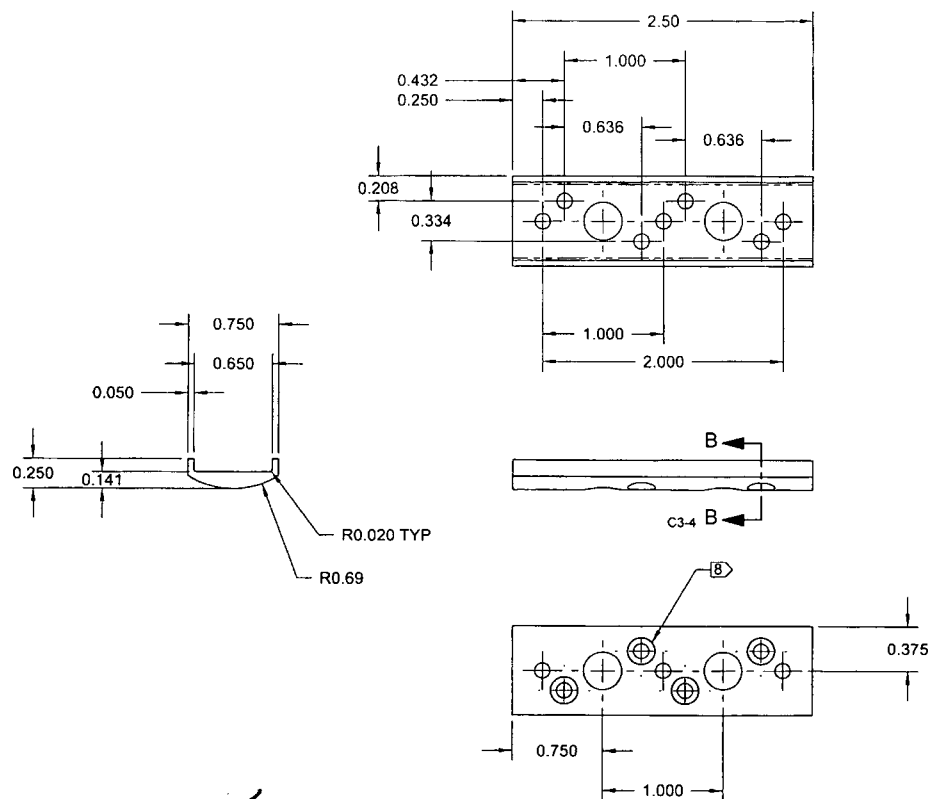
D3877-1 RADIUS BLOCK

RELEASED
9/6/21 M

NOTES:

- 1) MATERIAL: 5052-H32/H34 BAR PER QQ-A-225/7 (REF DART SPEC. M5052H32B0.750X00.250) OR 6061-T6 BAR PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC. M6061T6B0.750X00.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs
- 8) C'BORE INDICATED HOLES ON CURVED SIDE $\phi 0.230 \times 0.068$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$ (SEE SECTION A-A), 6 PL

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3877	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RADIUS BLOCK	NTS
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D3877-3 RADIUS BLOCK

NOTES:

- 1) MATERIAL: 5052-H32/H34 BAR PER QQ-A-225/7 (REF DART SPEC. M5052H32B0.750X00.250) OR 6061-T6 BAR PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC. M6061T6B0.750X00.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) C'BORE INDICATED HOLES ON CURVED SIDE $\phi 0.230 \times 0.068$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100^\circ$ (SEE SECTION B-B), 4 PL

RELEASED
9/15/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3877	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RADIUS BLOCK	NTS
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